

Item	Qty -141	Part Number	Description
1	X	D058-676-141	CROSSTUBE ASSEMBLY (OH-58 HIGH FWD)
2	1	D6001-105	CROSSTUBE
3	2	D2891-1	SUPPORT
4	4	D3595-063-395	RUBBER CUSHION
5	4	MS21920-20	CLAMP (OR MS21920-21)
6	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6001-105
FINISHED LENGTH = 103.03±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D058-676-141" AND BATCH NUMBER ON
INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 11.8 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER
QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE
THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS
ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

DEO ATTACHED

ECW #11-615
11.07.26
UNDER REVIEW
08/11/12

RELEASED
08/11/12

B	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); IDENTIFIED CROSSTUBE P/N (ZN C6-2); 0.780/500 WAS 0.700 (ZN B7-3); ADD/REMOVE REF. & ADD TOLERANCES (ZN D7-3, C4-3, C5-3 & D2-3); RELOCATED FLAG #6 (ZN A7-3) PER NCR 210; RE-ORDER TURNING DETAIL VIEW & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO. REV. B D058-676-141 SHEET 1 OF 4	
CHECKED	RF	TITLE SCALE CROSSTUBE ASS'Y (OH-58 HIGH FWD) NTS	
MFG. APPR.	RF	DATE 08.11.06	
APPROVED	RF	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.	RF		

8

7

6

5

4

3

2

1

12 D2891-1 SUPPORT
2 PL

15 MS21920-20 CLAMP
4 PL

13 D3595-063-395
RUBBER CUSHION
4 PL, (UNDER CLAMP)

D058-676-501

D058-676-141
ASSEMBLY DETAIL
(VIEW LOOKING FWD)

13 15
MS21920-20 CLAMP REF

12
D2891-1 SUPPORT REF

B
D3595-063-395
RUBBER CUSHION
REF

D5-2
SECTION B-B
SCALE 5X

C2-2
VIEW C-C: CUFF DETAIL
SCALE 4X

C7-2
VIEW A-A: CUFF DETAIL
SCALE 4X

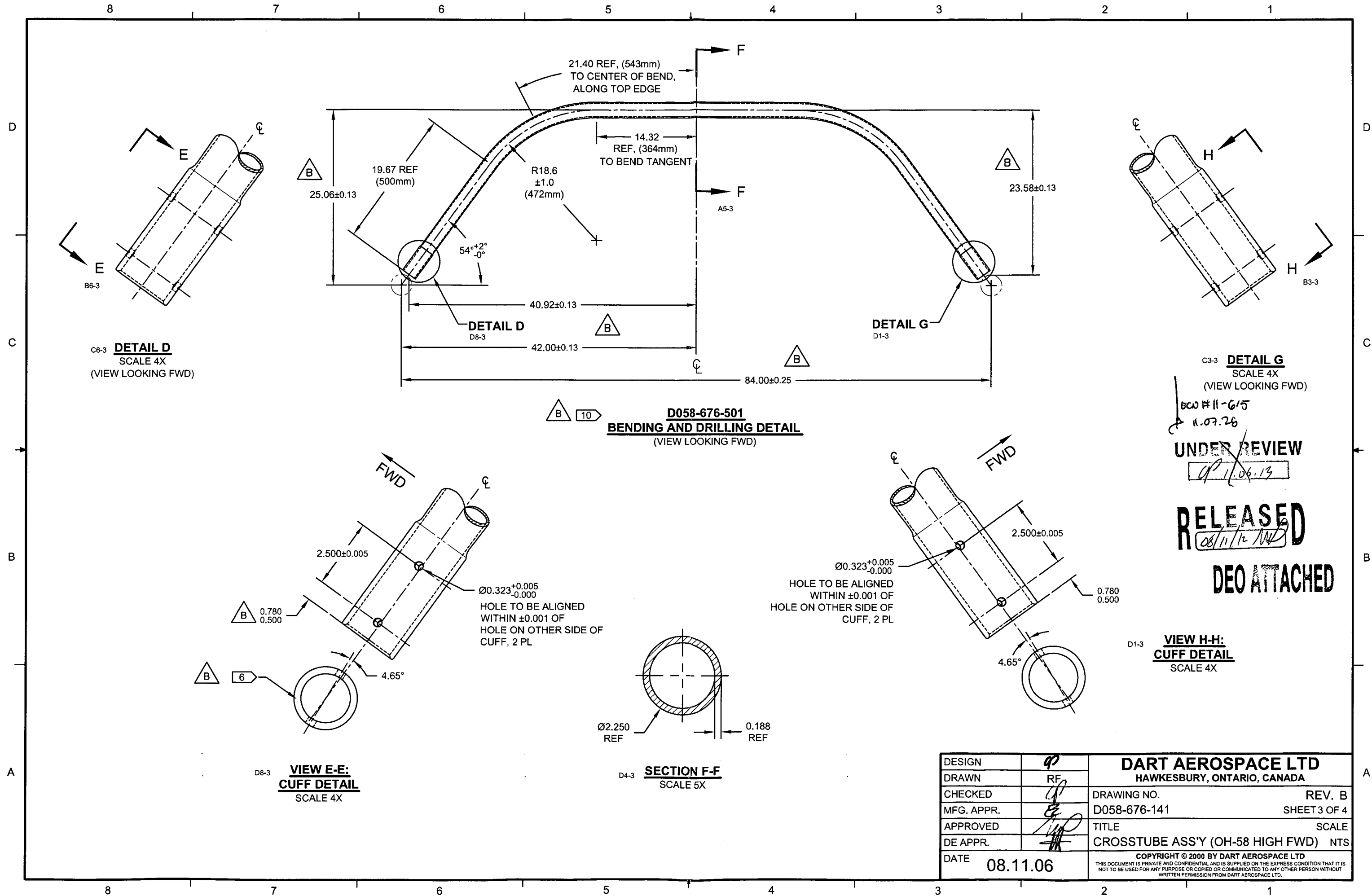
ECW #11-615
11.07.28

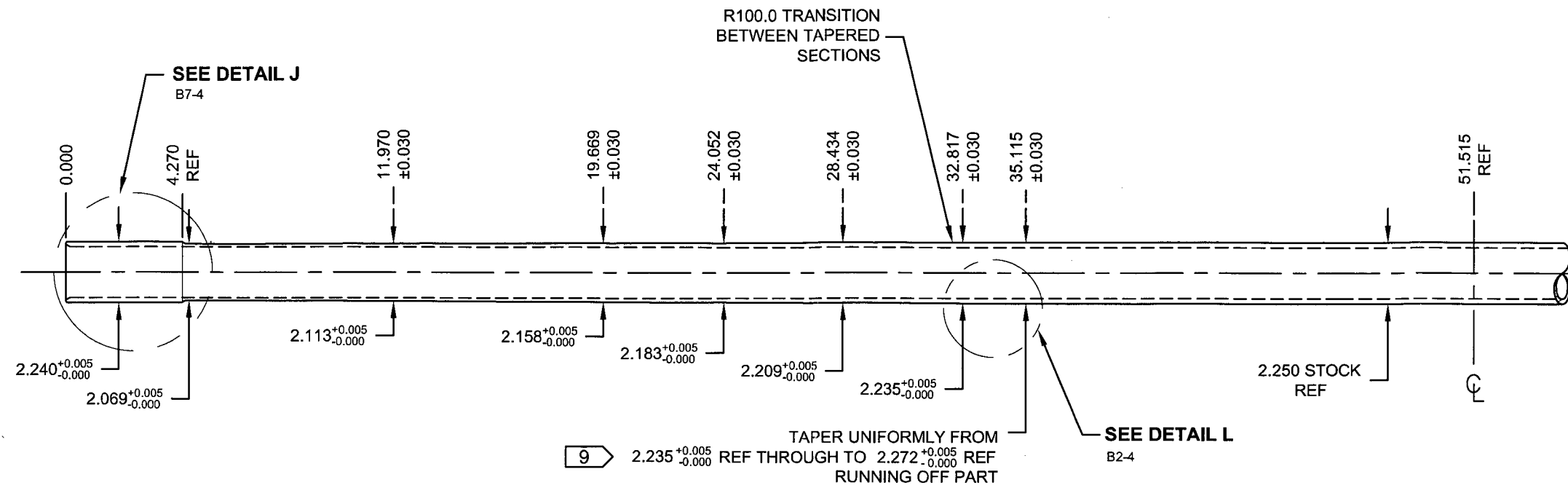
UNDER REVIEW
08/11/06

RELEASED
08/11/12

DEO ATTACHE

DESIGN	q	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	q	DRAWING NO.	REV. B
MFG. APPR.	E	D058-676-141	SHEET 2 OF 4
APPROVED	q	TITLE	SCALE
DE APPR.	q	CROSSTUBE ASS'Y (OH-58 HIGH FWD)	NTS
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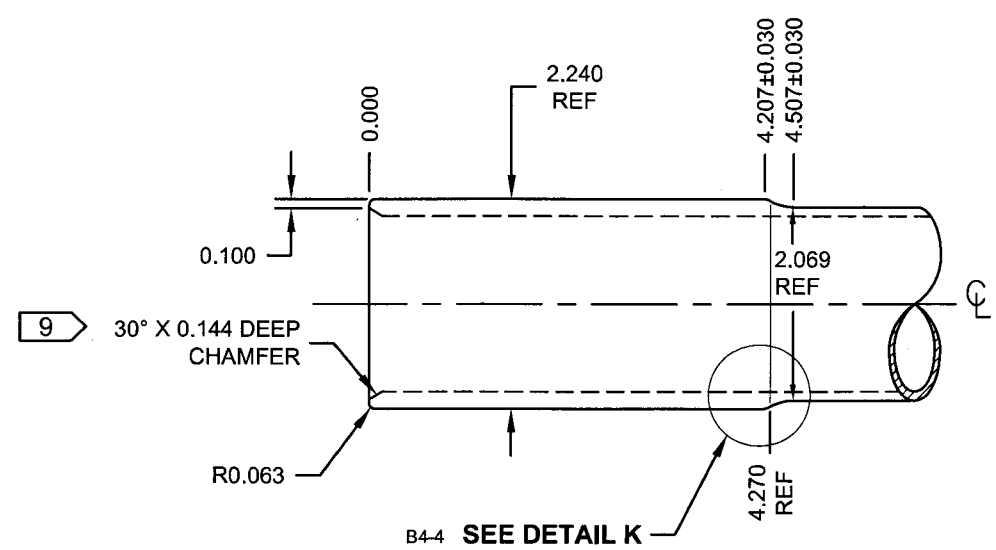
B TURNING DETAIL

ECN #11-615
1.07.26

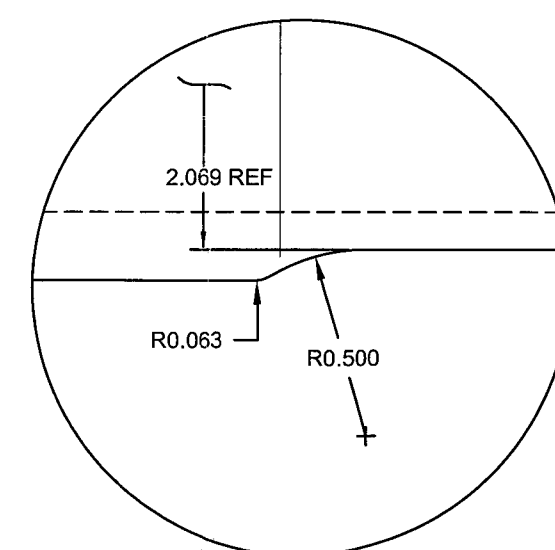
~~UNDER REVIEW~~
09/11/06.13

RELEASED
06/11/12

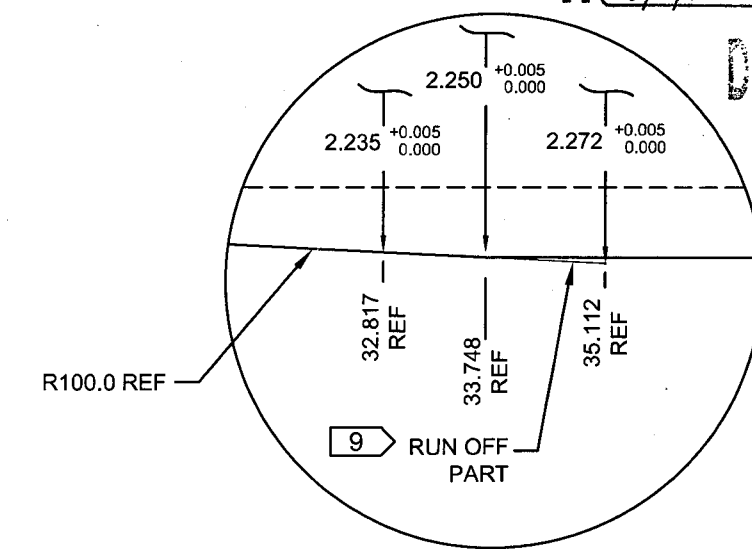
DETACHED



D7-4 **DETAIL J:
CROSTUBE CUFF**
NOT TO SCALE



A6-4 **DETAIL K:
CUFF TRANSITION**
NOT TO SCALE



D4-4 **DETAIL L:
TAPER RUN-OFF**
NOT TO SCALE

DESIGN	9	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D058-676-141	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSTUBE ASS'Y (OH-58 HIGH FWD)	NTS
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DRAWING NO. D058-676-141	TITLE CROSSTUBE ASS'Y (OH-58 HI FWD)	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D058-676-141-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>q</i>	CHECKED <i>ASS</i>	MFG. APPR. <i>18</i>	APPROVED <i>MP</i>		DE APPR. <i>#</i>		
DATE 11.07.15	DATE 11.07.20	DATE 11.07.21	DATE 11/07/21		DATE 11.07.21		

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

Item	Qty -141	Part Number	Description
6	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

6	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
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NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2891-1 SUPPORT: ABRABE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-07-28
MP